

इंटरनेट

मानक

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IS 12250 (1987): Fixed Clamp Supports [PGD 2: Machine Tool Elements and Holding Devices]



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Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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Indian Standard

SPECIFICATION FOR FIXED CLAMP SUPPORTS

1. Scope — Specifies dimensions and other requirements for fixed clamp supports to be used with goose neck clamps conforming to IS : 4279-1984 'Specification for goose neck clamps (*second revision*)', swing clamps conforming to IS : 5250-1984 'Specification for swing clamp (*first revision*)', wide clamp plates conforming to IS : 5252-1984 'Specification for wide clamp plates (*first revision*)', parallel sided clamp plates conforming to IS : 5998-1984 'Specification for parallel sided clamp plates (*first revision*)', and slotted clamps conforming to IS : 6082-1985 'Specification for slotted clamps (*first revision*)'.

2. Dimensions — Shall be as given in Table 1.

3. Material and Hardness — The material shall be suitable steel having tensile strength 600 to 750 N/mm² and hardened to 45 to 50 HRC.

4. Designation — A fixed clamp support having $d = 12$ mm and $l_2 = 32$ mm shall be designated as:

Fixed Clamp Support 12 × 32 IS : 12250

5. Workmanship — A fixed clamp support shall be free from cracks, burrs, pits and other defects.

6. Preservation and Packing

6.1 A suitable anti-corrosive surface treatment shall be given to fixed clamp supports.

6.2 These shall be packed in accordance with the best trade practice.

7. Marking — The fixed clamp support shall be marked at an appropriate place with designation and manufacturer's name or trade-mark.

7.1 Standard Marking — Details available with the Bureau of Indian Standards.

Adopted 28 December 1987

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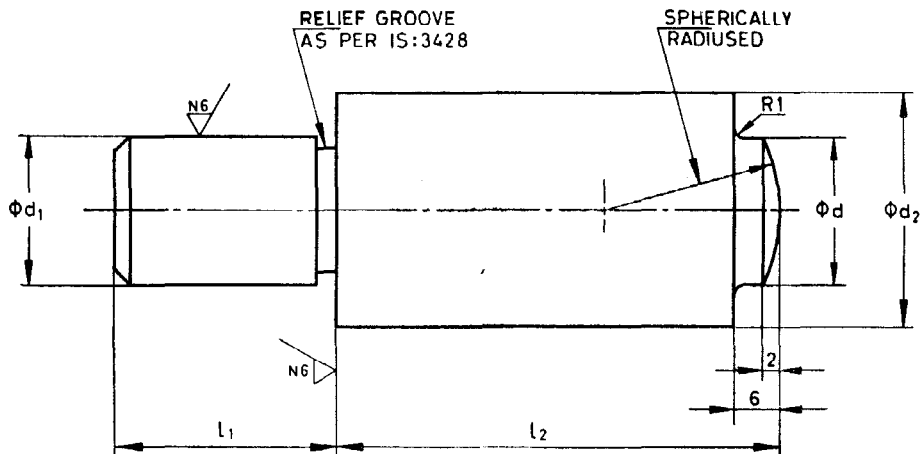
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TABLE 1 DIMENSIONS FOR FIXED CLAMP SUPPORTS
(Clause 2)

All dimensions in millimetres.

N9/ (N6/)



d	d_1	d_2	l_1	l_2											
0 -0.2	p6														
6	6	10	9	10	12	16	20	25	—	—	—	—	—	—	—
8	8	12	12	—	12	16	20	25	32	—	—	—	—	—	—
10	10	16	15	—	—	16	20	25	32	40	—	—	—	—	—
12	12	20	18	—	—	—	20	25	32	40	50	—	—	—	—
16	16	25	24	—	—	—	—	25	32	40	50	60	—	—	—
20	20	32	30	—	—	—	—	—	32	40	50	60	80	—	—
25	25	40	36	—	—	—	—	—	—	40	50	60	80	100	—
32	32	50	48	—	—	—	—	—	—	—	50	60	80	100	125

Note — Dimensional deviations for untoleranced dimensions shall be medium class according to IS : 2102 (Part 1)-1980 'General tolerances for dimensions and form and position: Part 1 General tolerances for linear and angular dimensions (second revision)'.

EXPLANATORY NOTE

This standard has been formulated to reduce the variety and rationalise the sizes of fixed heel clamp supports used in the industry.

In preparing this standard, assistance has been derived from BS : 5078-1974 'Fixed heel clamps, steel', issued by the British Standards Institution (BSI).